

Work Order ID 138171

138171

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Tuesday, October 27, 2015 11:05:07 AM

Item ID: D4711-043 Accept ***N19000040100*** Setup Start ***NS1***
 Revision ID: Stop ***NS2***
 Item Name: Expandable Pin Assembly
 Start Date: 10/26/2015 Start Qty: 6.00 ***6*** Cust Item ID:
 Required Date: 10/26/2015 Req'd Qty: 6.00 ***6*** Customer:
 Reference:

Approvals: Process Plan: MLJ Date: OCT 27 2015 Tooling: _____ Date: _____ Run Start ***NR1***
 QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
D4711	C

100 0.00
100
 Purchasing
 Purchasing
 Memo
 Issue P/O: 30322
 Possible supplier: Mc Master Carr
 Supplier P/N: 97787A661
 Material release note is required
 OCT 30 2015
 6

110 0.00
110
 Packaging
 Packaging
 Memo
 Receive & Inspect for Damage & Mat'l Certs
 68 8015-11-01

120 0.00
120
 QC
 Quality Control
 Memo
 QC6- Inspect dimensions to drawing
 6
 DAS
 38
 9-89
 NOV 04 2015

DQA: _____ Date: _____

**WORK ORDER NON-CONFORMANCE / UPDATE**

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY																																																																																																																											
Environment	☐	Design	☐	Doc/Data	☐	Equip/Tooling	☐	Handling/Pre	☐	Material	☐	Internal Transport	☐	Tribal Knowledge	☐	LOA	☐	Substation	☐	Past Expiry Date	☐	Misidentified	☐	No Re-verification	☐	Operator	☐	Offset/Setup	☐	Supplier	☐	Training	☐	Use for Testing	☐	Poor Information	☐	Rushing	☐	Product Improvement	☐	Process Improvement	☐	Manufacturing Process	☐	Past Due	☐	Pressure/Forced	☐	Bending	☐	Centre Not Concentric	☐	Cracks	☐	Crimp/Kink/Ripple/Wave	☐	Cuffs	☐	Crushing	☐	Heat Treat	☐	Wave/Twist in Tube	☐	Marks/Chatter	☐	Temperature/Cure	☐	Set-up	☐	BOM/Route	☐	Broken/Damage/Defect	☐	Inspection Incomplete/Unqualified	☐	Contamination	☐	Countersink	☐	Cut Too Short	☐	Instructions Incomplete/Unclear	☐	Drill Holes	☐	Power Loss/Surge	☐	Folio/Program	☐	Grain	☐	Weld	☐	Wrong Stock Pulled	☐	Out of Sequence	☐	Off-set	☐	Mislabeled	☐	Fit/Function	☐	Misaligned/off center	☐	Positioned Wrong	☐	Outside Dimensions	☐	Over/Under tolerance	☐	Part Incorrect	☐	Part Lost/Missing	☐	Part Moved	☐	Drawing	☐	Finish	☐	Misread	☐	Turning Sequence	☐
																								OTHER :																																																																																																							

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Page 2

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Item Name: Expandable Pin Assembly
Start Date: 10/26/2015 Start Qty: 6.00 ***6*** Cust Item ID:
Required Date: 10/26/2015 Req'd Qty: 6.00 ***6*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130	Identify as per dwg & Stock Location: <u>St120</u>	0.00							
130									
Packaging	Memo	0.00				<u>6</u>		DAS 6 9-99	
Packaging									
140	QC21- Final Inspection - Work Order Release	0.00							
140									
QC	Memo	0.01				<u>MLJ</u>		<u>1571-04</u>	
Quality Control									

NOV 04 2015

MLJ

NOV 04 2015

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval		
Description Work Order Deviation				Disposition					

Root Cause				FAULT CATEGORY																																																																																																																											
Environment	☐	Design	☐	Doc/Data	☐	Equip/Tooling	☐	Handling/Pre	☐	Material	☐	Internal Transport	☐	Tribal Knowledge	☐	LOA	☐	Substation	☐	Past Expiry Date	☐	Misidentified	☐	No Re-verification	☐	Operator	☐	Offset/Setup	☐	Supplier	☐	Training	☐	Use for Testing	☐	Poor Information	☐	Rushing	☐	Product Improvement	☐	Process Improvement	☐	Manufacturing Process	☐	Past Due	☐	Pressure/Forced	☐	Bending	☐	Centre Not Concentric	☐	Cracks	☐	Crimp/Kink/Ripple/Wave	☐	Cuffs	☐	Crushing	☐	Heat Treat	☐	Wave/Twist in Tube	☐	Marks/Chatter	☐	Temperature/Cure	☐	Set-up	☐	BOM/Route	☐	Broken/Damage/Defect	☐	Inspection Incomplete/Unqualified	☐	Contamination	☐	Countersink	☐	Cut Too Short	☐	Instructions Incomplete/Unclear	☐	Drill Holes	☐	Power Loss/Surge	☐	Folio/Program	☐	Grain	☐	Weld	☐	Wrong Stock Pulled	☐	Out of Sequence	☐	Off-set	☐	Mislabeled	☐	Fit/Function	☐	Misaligned/off center	☐	Positioned Wrong	☐	Outside Dimensions	☐	Over/Under tolerance	☐	Part Incorrect	☐	Part Lost/Missing	☐	Part Moved	☐	Drawing	☐	Finish	☐	Misread	☐	Turning Sequence	☐
OTHER : _____																																																																																																																															

Picklist Print

Tuesday, October 27, 2015 11:05:07 AM

Page 1

Work Order ID: 138171

138171

Parent Item: D4711-043

D4711-043

Parent Item Name: Expandable Pin Assembly

Start Date: 10/26/2015

Required Date: 10/26/2015

Start Qty: 6.00

Required Qty: 6.00

Comments: IPP REV:B 12.10.16 AS PER DWG REV.A DD VERF:JFS

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
97787A661		Purchased		No		110	Each	0.0000	1	6			
97787A661										**			
Expandable Pin													

Gr 8D 15 11-01

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

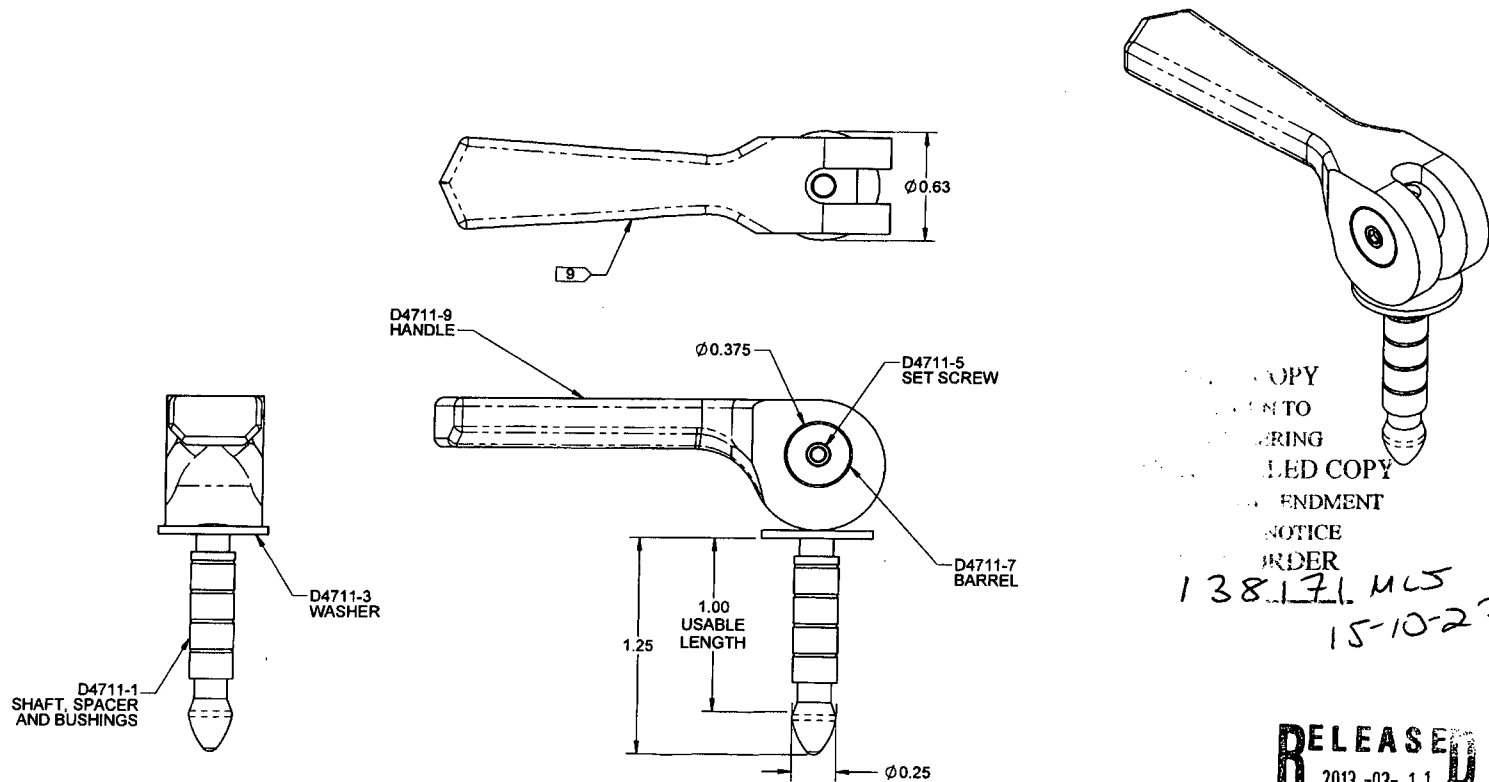
QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
Date :		Step #:		QTY Effective :			MRB (QSI042) Approval 		
Description Work Order Deviation				Disposition					
							Completed By		
							Lead hand / Supervisor Approval Verification		
							QC / QA Coordinator Approval		

Root Cause				FAULT CATEGORY							
Environment	☐	No Re-verification	☐	Pressure/Forced	☐	Temperature/Cure	☐	Power Loss/Surge	☐	Positioned Wrong	☐
Design	☐	Operator	☐	Bending	☐	Set-up	☐	Folio/Program	☐	Outside Dimensions	☐
Doc/Data	☐	Offset/Setup	☐	Centre Not Concentric	☐	BOM/Route	☐	Grain	☐	Over/Under tolerance	☐
Equip/Tooling	☐	Supplier	☐	Cracks	☐	Broken/Damage/Defect	☐	Weld	☐	Part Incorrect	☐
Handling/Pre	☐	Training	☐	Crimp/Kink/Ripple/Wave	☐	Inspection Incomplete/Unqualified	☐	Wrong Stock Pulled	☐	Part Lost/Missing	☐
Material	☐	Use for Testing	☐	Cuffs	☐	Contamination	☐	Out of Sequence	☐	Part Moved	☐
Internal Transport	☐	Poor Information	☐	Crushing	☐	Countersink	☐	Off-set	☐	Drawing	☐
Tribal Knowledge	☐	Rushing	☐	Heat Treat	☐	Cut Too Short	☐	Mislabeled	☐	Finish	☐
LOA	☐	Product Improvement	☐	Wave/Twist in Tube	☐	Instructions Incomplete/Unclear	☐	Fit/Function	☐	Misread	☐
Substation	☐	Process Improvement	☐	Marks/Chatter	☐	Drill Holes	☐	Misaligned/off center	☐	Turning Sequence	☐
Past Expiry Date	☐	Manufacturing Process	☐	OTHER : _____							
Misidentified	☐	Past Due	☐								

SPECIFICATION CONTROL DRAWING



D4711-043 EXPANDABLE PIN ASSY

NOTES:

- 1) MATERIAL: CORE PIN, SPLIT RINGS & BARREL: STAINLESS STEEL 17-4 PH CONDITION H925 PER AMS 5643
- 2) FINISH: N/A
- 3) TOLERANCES: N/A
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: N/A
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.14 lbs
- 8) RECOMMENDED SUPPLIER: MCMASTER CARR P/N 97787A661
- 9) HANDLE, BARREL AND SET SCREW TO BE DISCARDED AT NEXT HIGHER ASSEMBLY

DESIGN	RP	DART AEROSPACE USA, INC.	
DRAWN	AP	KENT, WA	
CHECKED	AS	DRAWING NO.	REV. C
MFG. APPR.	al	D4711	SHEET 2 OF 2
APPROVED	af	TITLE	SCALE
DE APPR.		ADJUSTABLE DIAMETER PIN	NTS
DATE	13.02.12	COPYRIGHT © 2012 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMES OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

RELEASED
2013-03-11



Dart Aerospace Ltd.
1270 Aberdeen Street
Hawkesbury, ON K6A 1K7
Tel: 613 632 9577
Fax: 613 632 1053

PURCHASE ORDER

Purchase Order ID **PO30322**

Purchase Order Date 10/30/2015

PO Print Date 10/30/2015

Page Number 1 of 3

Order From :

VU-MCM001

Ship To : DART AEROSPACE LTD

MCMASTER-CARR SUPPLY CO,
P.O. BOX 7690
CHICAGO, IL 60680-7690
US

1270 ABERDEEN
HAWKESBURY, ON K6A 1K7
CANADA

FAKED

Contact Name

Vendor Phone 330 995 5500

Buyer

Chantal Lavoie

Customer POID

Customer Tax #

10127-2607

Terms

Net 10

Currency

USD

FOB

FCA - (Free Carrier)

Ship To Contact

Ship To Phone

Ship Via:

Purolator ground ppd

Ship Acct:

Line Nbr	Reference Vendor Part Number Line Comments Delivery Comments	Description/ Mfg ID	Req Date/ Taxable Promise Date	CD	Req Qty/ Unit of Measure	PO Unit Price	Extended Price
1	9928K53 AS PER DWG D4287 REV. A B138255	UHMW U-Channel	11/3/2015 Yes 11/3/2015		16.00 f ✓ <i>Sps 11-02</i>	\$2.28	\$36.48
Line Total:							\$36.48
2	97787A661 AS PER DWG D4711 REV. C B138171	Expandable Pin	11/3/2015 Yes 11/3/2015		6.00 Each <i>Sps 11-03</i>	\$114.68	\$688.08
Line Total:							\$688.08
3	92311A639 AS PER DWG D2747 REV. B B138333	SS SET SCREW	11/3/2015 Yes 11/3/2015		50.00 Each	\$0.66	\$33.10

Note:

10/30/2015

200 Aurora Industrial Pkwy
Aurora OH 44202-8087
330-995-5500
cle.sales@mcmaster.com

Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury ON K6A 1K7
Canada

Purchase Order
PO30322

Order Placed By
Chantal Lavoie

McMaster-Carr Number
2769572-02

Page 1 of 1

10/30/2015

Line	Product	Ordered	Shipped
2	97787A661 Expanding Diameter Quick-Release Pin, 1/4" Diameter, 1" Usable Length	6 Each	6
3	92311A639 18-8 Stainless Steel Cup Point Set Screw, 3/8"-24 Thread, 1" Long, Packs of 10	5 Packs	5
4	7510A653 Plastic Syringe, Manual, with Luer Lock Connection, .34 oz Capacity, Packs of 10	10 Packs	10 ✓
5	44455A67 1/4" Shank-Mount Low Scratch Cleaning Brush, for Stainless Steel and Aluminum, 3" Brush Diameter, 0.006" Bristle Diameter	8 Each	8 ✓
6	5346K13 Brass Barbed Hose Fitting, Adapter for 1/4" Hose ID X 1/8" NPTF Male Pipe, Packs of 10	1 Pack	1 ✓
7	6763K82 Miniature Air Regulator with Pressure Gauge, Aluminum Body, 1/4 Pipe, 10 Max SCFM, 0-25 PSI Range	1 Each	1 ✓

805-11-03

McMaster-Carr Supply Company
200 Aurora Industrial Pkwy
Aurora, OH 44202-8087 USA
Phone: 330-995-5500 Fax: 330-995-9600
E-Mail: cl_sales@mcmaster.com
Employer Identification Number (EIN): 36-1458720

Invoice: 42504082
Purchase Order: PO30322
Release:
McMaster-Carr Number: 2769572-02

ORIGINAL COMMERCIAL
INVOICE
CERTIFICATE OF ORIGIN

Ultimate Destination:
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury ON K6A 1K7
Canada

Shipped: 30-Oct-2015 FOB: ORIGIN
Shipper's Export Declaration (SED):
NO EEI 30.36

Intermediate Consignee:

Bill To:
Dart Aerospace Ltd
1270 Aberdeen St
Hawkesbury ON K6A 1K7
Canada

Tax Number:

Forwarding Agent:

Billing
Attention:
Shipping
Attention:
Contact:

Line	Description	Qty & Unit	Unit Price	Extension
2	97787A661 Expanding Diameter Quick-Release Pin, 1/4" Diameter, 1" Usable Length Country of Origin: United States Schedule B #: 731829 ECCN #: 9A991 NLR	6 EA	\$114.68	\$688.08
3	92311A639 18-8 Stainless Steel Cup Point Set Screw, 3/8"-24 Thread, 1" Long, Packs of 10 Country of Origin: Taiwan Schedule B #: 731815 ECCN #: EAR99 NLR	5 PK	\$6.60	\$33.00
4	7510A653 Plastic Syringe, Manual, with Luer Lock Connection, .34 oz Capacity, Packs of 10 Country of Origin: United States Schedule B #: 392690 ECCN #: EAR99 NLR	10 PK	\$8.39	\$83.90
5	44455A67 1/4" Shank-Mount Low Scratch Cleaning Brush, for Stainless Steel and Aluminum, 3" Brush Diameter, 0.006" Bristle Diameter Country of Origin: United States Schedule B #: 960350 ECCN #: EAR99 NLR	8 EA	\$22.09	\$176.72
6	5346K13 Brass Barbed Hose Fitting, Adapter for 1/4" Hose ID X 1/8" NPTF Male Pipe, Packs of 10 Country of Origin: United States Schedule B #: 741220 ECCN #: EAR99 NLR	1 PK	\$10.20	\$10.20

Your order is subject only to our terms and conditions, available at www.mcmaster.com or from our Sales Department.

These commodities, technology, or software were exported from the United States in accordance with Export Administration regulations. Diversion contrary to US law is prohibited.

Shipping Weight (in kgs): 3

Number of Packages: 1

Invoice Amounts:

Merchandise Amount: \$1,033.36
Canadian GST/HST: \$136.10
Shipping Charges: \$13.56
Total (In USD): \$1,183.02

Package Dimensions:

47 X 21 X 17 CM = .017 CUBIC M

Payment Terms: 2% discount on merchandise only if paid within 10 days, net 30 days

Remit payment to:
(by mail)
McMaster-Carr Supply Company
PO Box 7690
Chicago, IL 60680-7690 USA

(by wire transfer)
Bank of America Illinois
231 S LaSalle
Chicago, IL 60697
ABA 071000039 Account 86666-02021
SWIFT BOFAUS3N

Authorized Signature:

Date:

30-Oct-2015

Name: Sarah Weinberg

Title: Operations Mgr.

Page 1 of 2

McMaster-Carr Supply Company
200 Aurora Industrial Pkwy
Aurora, OH 44202-8087 USA
Phone: 330-995-5500 Fax: 330-995-9600
E-Mail: cle.sales@mcmaster.com
Employer Identification Number (EIN): 36-1458720

Invoice: 42504082
Purchase Order: PO30322
Release:
McMaster-Carr Number: 2769572-02

ORIGINAL COMMERCIAL
INVOICE
CERTIFICATE OF ORIGIN

Line	Description	Qty & Unit	Unit Price	Extension
7	6763K82 Miniature Air Regulator with Pressure Gauge, Aluminum Body, 1/4 Pipe, 10 Max SCFM, 0-25 PSI Range Country of Origin: United States Schedule B #: 848110 ECCN #: EAR99 NLR NOTE Tracking number(s) for this shipment: MFA004492879	1 EA	\$41.46	\$41.46

Number of Packages: 1